

Date: Thursday, 14/08/2008 8:21:44 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INSTRUMENT PANEL ASSY
 Job Number : 41224
 Estimate Number : 13352
 P.O. Number :
 This Issue : 14/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 14/08/2008 Type : R & D SM/MED FAB
 Previous Run : 05018
 Part Number : D3705041
 Drawing Number : D3705 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 15/08/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *MF 08-08-14*
 Comment : Est Rev:A new issue 08-05-30 DD verified by:ec

Additional Product

PRELIMINARY ISSUE PROTOTYPE

Job Number:



08.08.22
D

FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D33351 Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Short Spring
 batch: _____

3.0 D3705043 Instrument Panel Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Instrument Panel Weldment
 batch: _____

4.0 D37055 Access Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Access Panel
 batch: _____

5.0 D37065 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pin
 batch: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASS'Y

Job Number: 41224

Part Number: D3705041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D37073	MOUNTING LUG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
MOUNTING LUG
batch: _____

7.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
batch: _____

8.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: _____

9.0	MS171498	Spring Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spring Slotted Pin
batch: _____

10.0	MS20426AD33	Rivet
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Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)
Rivet
batch: _____

11.0	MS21075L3	Nutplate
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Nutplate
batch: _____

12.0	MS24693C272	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
batch: _____

Date: Thursday, 14/08/2008 8:21:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASS'Y

Job Number: 41224

Part Number: D3705041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS27039109

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: _____

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble parts as per dwg D3705

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

08.08.12

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

FOR ENGINEERING USE ONLY

08.08.12

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



09.01.26

POSITIVE RECALL

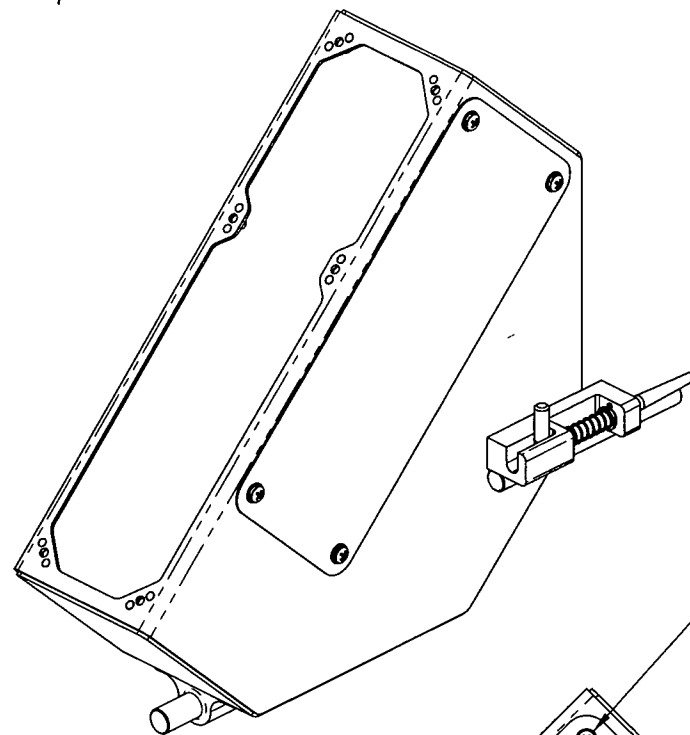
EFFECTIVE 09.01.14

RELEASED

AUTH

DATE

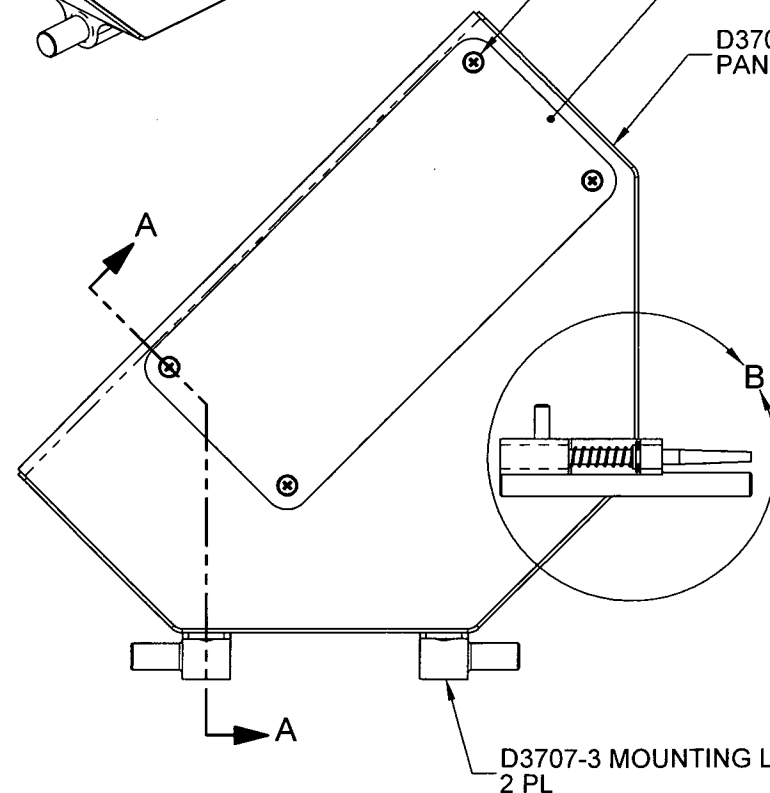
09.02.17



MS27039-1-09 SCREW
AN960JD10L WASHER
4 PL

D3705-5
ACCESS PANEL

D3705-043 INSTRUMENT
PANEL WELDMENT



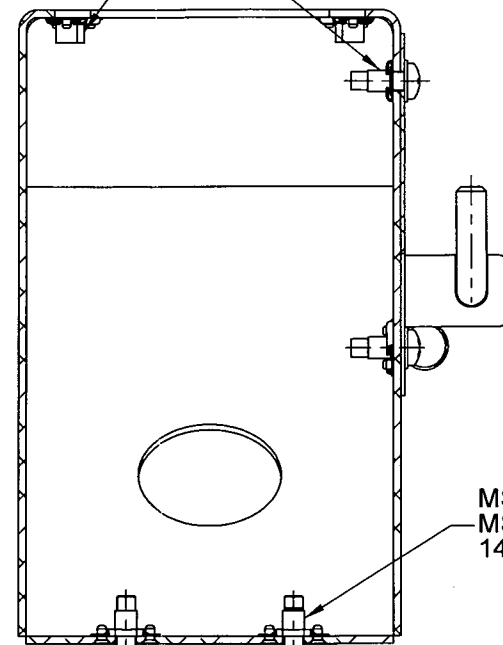
D3707-3 MOUNTING LUG
2 PL

D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.55 lbs

MS21075L3 NUTPLATE
REF



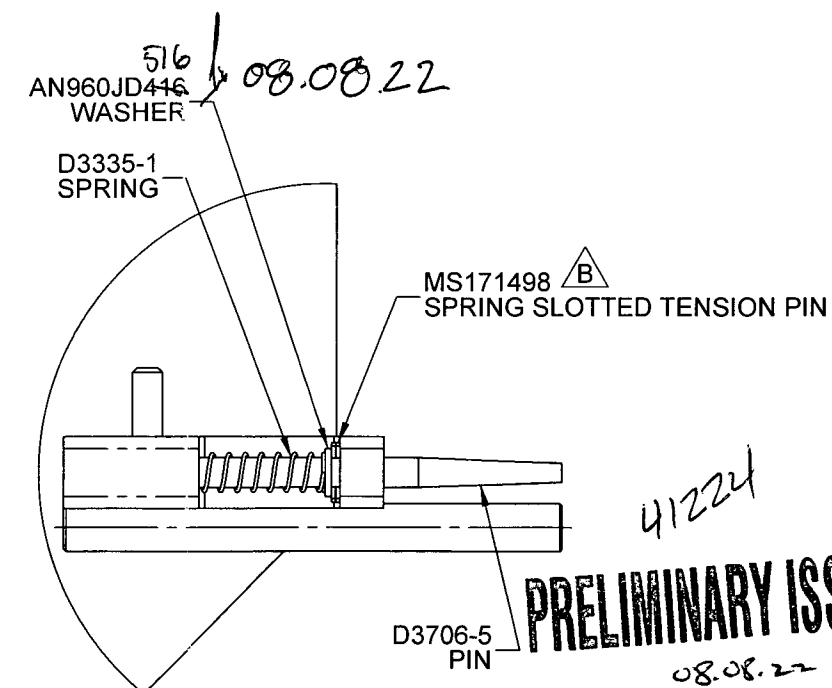
MS21075L3 NUTPLATE, 1X
MS20426AD3-3 RIVET, 2X
14 PL

MS24693-C272 SCREW
4 PL

D3707-3 MOUNTING LUG
REF

SECTION A-A SCALE 2X

QTY -041	P/N	DESCRIPTION
X	D3705-041	INSTRUMENT PANEL ASS'Y
1	D3335-1	SPRING
1	D3705-043	INSTRUMENT PANEL WELDMENT
1	D3705-5	ACCESS PANEL
1	D3706-5	PIN
2	D3707-3	MOUNTING LUG
1	AN960JD416	WASHER
4	AN960JD10L	WASHER
1	MS171498	SPRING SLOTTED TENSION PIN
28	MS20426AD3-3	RIVET
14	MS21075L3	NUT PLATE
4	MS24693C272	SCREW
4	MS27039-1-09	SCREW



DETAIL B SCALE 2X

PRELIMINARY ISSUE
08.08.22

PROTOTYPE

B	QTY.14 MS21075L3 WAS QTY.8 (ZN D3-1); QTY.28 MS20426AD3-3 WAS QTY. 16 (ZN D3-1); MS171498 WAS TP-2 (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Date: Tuesday, 19/08/2008 1:49:06 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 41224 Estimate Number : 13352 P.O. Number : This Issue : 19/08/2008 S.O. No. : Prsht Rev. : NC First Issue : 14/08/2008 Type : R & D SM/MED FAB Previous Run : 05018 Written By : Checked & Approved By : Comment : Est Rev:A new issue 08-05-30 DD verified by:ec	Drawing Name : INSTRUMENT PANEL ASS'Y Part Number : D3705041 Drawing Number : D3705 PROTO 08.08.14 Project Number : N/A Drawing Revision : PROTO Material : Due Date : 15/08/2008 Qty: 1 Um: Each
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Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D33351	Short Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Short Spring
 batch: B35444

3.0	D3705043	Instrument Panel Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Instrument Panel Weldment
 batch: D41227

41227

4.0	D37055	Access Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Access Panel
 batch: B05038

5.0	D37065	Pin
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pin
 batch: B05019

05019

Date: Tuesday, 19/08/2008 1:49:06 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASSY

Job Number: 41224

Part Number: D3705041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D37073

MOUNTING LUG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

MOUNTING LUG

batch: B38692

38692

(P1) see last page

7.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M107534

8.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104885

9.0

MS171498

Spring Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spring Slotted Pin

batch: M16588

10.0

MS20426AD33

Rivet



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Rivet

batch: NA

NA 108.08.22

11.0

MS21075L3

Nutplate



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nutplate

batch: NA

NA 108.08.22

12.0

MS24693C27

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M107394

M8815

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3705-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/02/19
 QA: N/C Closed: _____ Date: _____

NCR: <u>41224</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/22</u>	<u>6.0</u>	<u>2x D3707-3's have markings in them. Marks were put onto the parts for the structural tests.</u>	<u>08/08/22</u>	<u>- Parts acceptable for now. Assy is going for a trial fit, i.e. flight test. <u>only</u></u>	<u>08/08/22</u>	<u>08/08/22</u>	<u>08/08/22</u>	<u>08/08/22</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASS'Y

Job Number: 41224

Part Number: D3705041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS27039109

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: 1167378 M1892

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble parts as per dwg D3705

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

ENGINEERING
USE ONLY

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



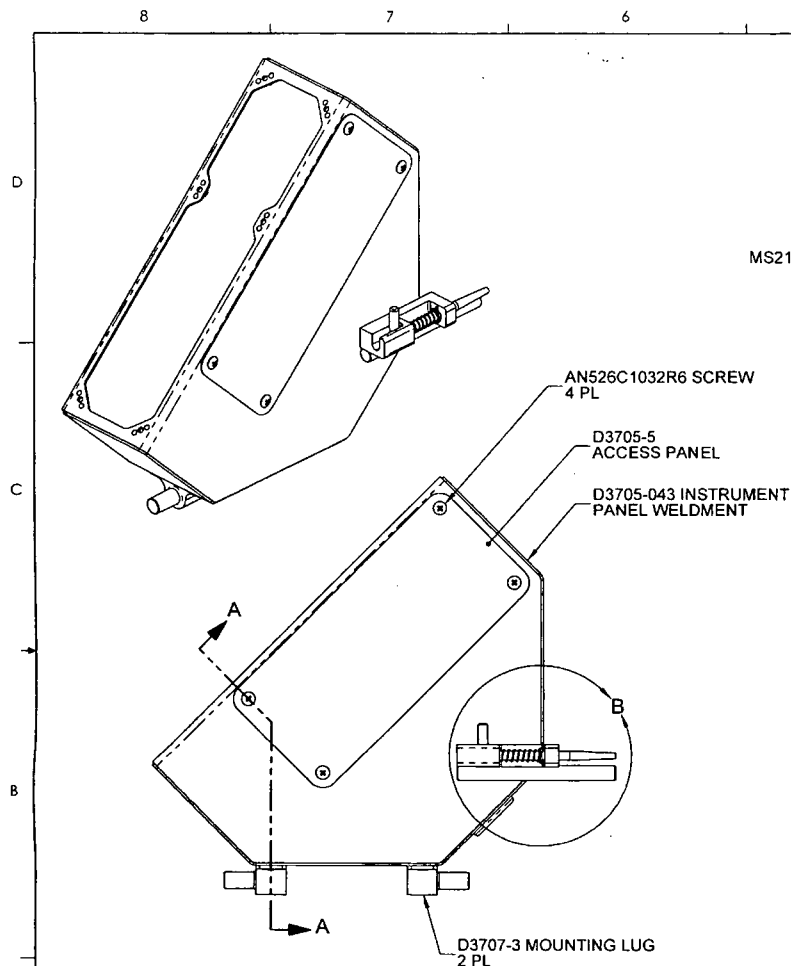
POSITIVE RECALL

REACTIVE

AUTH LA

ED

DATE 08.08.22

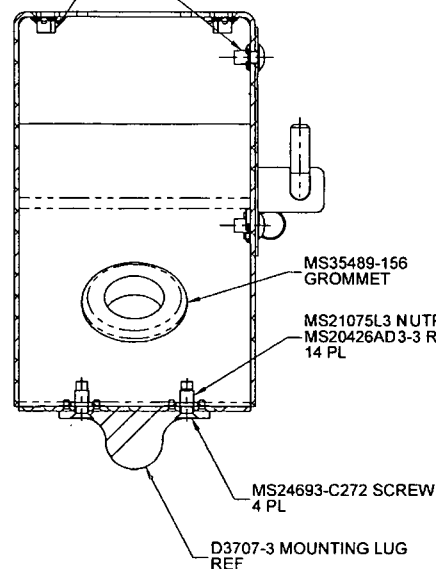


D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

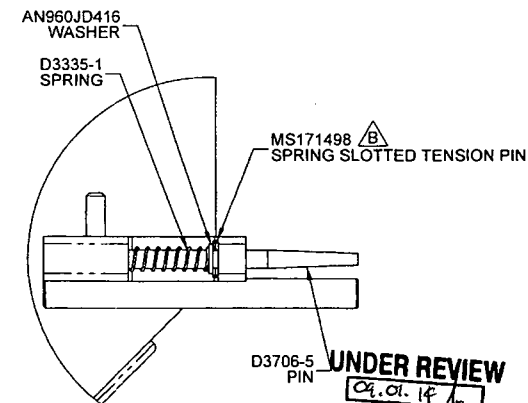
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.55 lbs

MS21075L3 NUTPLATE
REF



SECTION A-A
SCALE 2X

QTY -041	P/N	DESCRIPTION
X	D3705-041	INSTRUMENT PANEL ASS'Y
1	D3335-1	SPRING
1	D3705-043	INSTRUMENT PANEL WELDMENT
1	D3705-5	ACCESS PANEL
1	D3706-5	PIN
2	D3707-3	MOUNTING LUG
4	AN526C1032R6	SCREW
1	AN960JD416	WASHER
1	MS171498	SPRING SLOTTED TENSION PIN
28	MS20426AD3-3	RIVET
14	MS21075L3	NUT PLATE
4	MS24693C272	SCREW
1	MS35489-156	GROMMET



DETAIL B
SCALE 2X

UNDER REVIEW
01.01.18
182 BOW #08-566

RELEASED
09/07/18

B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 15; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. B
SHEET 1 OF 5
TITLE **INSTRUMENT PANEL ASS'Y** SCALE NTS

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41224